



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G09031-3G-PO

Job Sheet 191016



Part No: RBW6205G09031-3G-PO **Job Qty:** 2 pcs

Part Name: Main Rotor Head Support - Trolley Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: ~~4/24/19~~ 5/30/2019

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G09031-3G Rev.3 IPP Rev. A 18.10.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	2 pcs	4/24/19	4/24/19	0.00	0.00	Purchasing - 1	MAY 30 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	4/24/19	4/24/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	MAY 30 2019
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S185518



Part: RBW6205G09031-3G

Job No: 191016

Serial No/Batch: S185518

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/30/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	4/24/19	0.00 0.00	QC 6 - 42		
				QC 6 - 9		
				QC 6 - 68		
				QC 6 - 61		
130 Packaging 3-1 - Stock - B4B	2 pcs	4/24/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
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				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140 QC 21 - FG	2 pcs	4/24/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - SA - 53		

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Part Op 100 - (Purchasing) Issue P/O: 042669 MANUFACTURE RBW6205G09031-3G AS PER DWG Supplier: METEC
 Descriptions: Certificate of conformity is required

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____) The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

140 - (QC21- Final Inspection - Work Order Release)

x2 Alus

20 Feb 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBW6205G09031-3GP	Main Rotor Head Support - Trolley Adapter	2 pcs (1 ea)	100-Purchasing	5185515

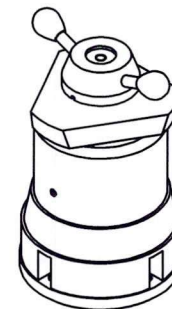
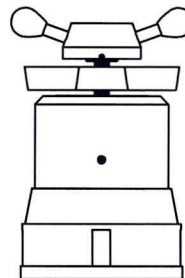
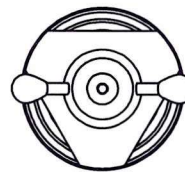
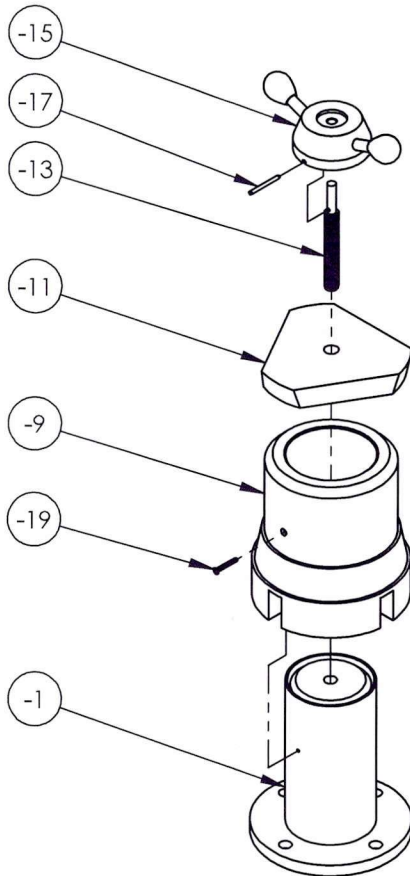
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G09031-3GP	2	0	0

Part Specifications
Specifications could not be found.

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		REDRAWN IN SOLIDWORKS. CH'D TOOL NUMBER WAS RBW6205G09031 IS RBW6205G09031-3G. CH'D DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. -1 CH'D FINISH WAS BLACK OXIDE IS BLACK ZINC. -3 CH'D O.D. WAS Ø3.430 S.F. -5 IS Ø3.500 S.F. -5. -5 CH'D DIM. WAS Ø3.430 S.F. -3 IS Ø3.500 S.F. -3. REF. DIM. WAS Ø3.726 IS Ø3.797. -7 CH'D O.D. WAS Ø6.848 IS Ø7.00 CH'D B.C. WAS Ø5.375 IS Ø5.512 CH'D DIM WAS Ø3.758 IS S.F. Ø3.758. -9 CH'D HOLE WAS C-SINK Ø.41 @ 100° ±.11 IS ✓ Ø.33 X 82° CH'D ENGRAVE NOTE WAS "T/N, S/N, AND MADE IN USA" IS "RBW6205G09031-3G-9" -11 ADDED DIMENSIONS 3X 2.50, (2X 60°), (3X 11°) CH'D ENGRAVE NOTE WAS "T/N, S/N, AND MADE IN USA" IS "RBW6205G09031-3G-9" -13 CH'D CALLOUT WAS Ø.394 S.F. -9 IS Ø.394 S.F. -15. -15 ADDED COUNTER BORE WAS Ø.159 THRU ALL IS Ø.159 ±.030 Ø.201 ±.015. -15 ADDED ALTERNATE B/O# TO BOM IS ELSA CODE #65801.	8/21/2013	CFS
2		CH'D TITLEBLOCK WAS RED BARN IS DART. -1 ADDED HOLE AND LOCATION DIMS FOR 8-32 HOLE. -5 DELETED HOLE AND DIMS 8-32 ±.5, 4.777.	6/9/2014	DPD
3	15-0041	-13 CH'D FINISH WAS BLACK ZINC IS SILVER ZINC.	2/20/2015	RJC



NOTE:

1. REF. AGUSTA T/N: 3G6205G09031.
2. TOOL USED W/ RBW6005G00131-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	PIN WELDMENT			2
	1		-3		PIN TOP	1018		3
	1		-5		TUBE	STEEL DOM TUBING		4
	1		-7		BOTTOM RING	1018 RND BAR		5
			-9	1	COVER	DELIN TUBING		6
			-11	1	TOP	DELIN		7
			-13	1	THREADED ROD (HEX BOLT)	GR.5, PLATED	5/8-18 UNF X 5-5/8 (MCMaster-CARR #92865A452) MODIFIED	8
			-15	1	TWO-ARM HAND WHEEL		(ELSA CODE #65801, REID #ELC-20) MODIFIED	9
		B/O	-17	1	SLOTTED ROLL PIN	STEEL	Ø5/32 X 1-3/4 (MCMaster-CARR #90692A716)	1
		B/O	-19	1	FLAT HEAD SCREW	ZINC PLATED STEEL	82°, #8-32 UNF X 1-1/4 (MCMaster-CARR #90273A201)	1
	ASSY -1							



TITLE		TROLLEY ADAPTER, M/R HEAD SUPPORT	
DWG NO.		RBW6205G09031-3G	
REV		3	
MAT'L		DRAWN BY: PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED D Weil	
.XXX ± .005		FRACTIONS ± 1/32	
.XX ± .01		ANGLES ± .5°	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AGUSTA	
SCALE 1:8		DATE 4/23/2009	
		SHEET 1 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042669



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042669

PO Date: 2/20/19

Due Date: ~~4/24/19~~ 4/25/2019

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lussier, PatrickPhone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191014	RBW6005G00131-3GP			Multi-Purpose Trolley REV 5	Firmed	-	4/24/19	1 pcs	0 pcs	1 pcs	\$3,205.00/pcs	\$3,205.00
2	191020	RBW6205G00632-3GP			Sling, Main Rotor Blade Lift As per Dwg RBW6205G00632-3G Rev. 6	Firmed	-	4/24/19	2 pcs	0 pcs	2 pcs	\$5,980.00/pcs	\$11,960.00
3	191016	RBW6205G09031-3GP			Main Rotor Head Support - Trolley Adapter REV 3	Firmed	-	4/24/19 5/30/2019	2 pcs	0 pcs	2 pcs	\$1,430.00/pcs	\$2,860.00
4	191019	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	4/24/19 5/30/2019	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
												Grand Total:	\$18,325.00

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Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042669



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Att. Patrick Lussier
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25305
Shipment Date: 27-May-2019
Ship Via: Pick up at METEC
Order Number: 3520
Order Date: 02/20/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: P0042669 ✓
Terms: Net 60 Days

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
3	2	2 ✓	0	0	EA	RBW6205G09031-3GP Trolley Adapter, M/R Head Support	3	3520-03

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RECEIVED

MAY 30 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Att. Patrick Lussier



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2 ✓	RBW6205G09031-3GP ✓	Trolley Adapter, M/R Head Support	3	42669 ✓

MATERIAL: supplied by METEC

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We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Theoret

Vankleek Hill, May 27, 2019